

Date: Wednesday, 15/08/2007 3:51:49 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 33925A
Estimate Number : 10163
P.C. Number : Part Number : D206642241
This Issue : 15/08/2007 S.O. No. : Drawing Number : D2650 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : LANDING GEAR Drawing Revision : E
Previous Run : 33776A Material :
Written By : Due Date : 07/09/2007 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:M 04/12/02 Revised procedural steps KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG003

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2620 Bent Tube 3" OD B23880

BE 07-08-28

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3286-1 Doubler D33092

7-9-20

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2647 Fwd Cap B29328

BE 07-08-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

BE 07-08-28

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

BE 07-08-28

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

M104221
M105058

BE 07-08-28

4-Grind weld flush to cap on top surface only.

BE 07-08-28

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

DP
7-9-6

2920

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| 6.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

SL 07/10/11

| | | |
|-----|----------------|-------------------------|
| 7.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

- 1-Open crossbolt holes to $\varnothing 0.3125$ " as per Dwg D2650
- 2-Drill pilot holes using DT8028-3, then open to $\varnothing 0.297$ " as per Dwg D2650. Open Aft cap hole #6.
- 3-Deburr tube and blow out chips from inside the tube

SL 7-10-11
ID

| | | |
|-----|-----------------|----------------------------|
| 8.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 07/10/11

| | | |
|-----|-----|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07/10/11

| | | |
|------|----------------|-------------------------|
| 10.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|------|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

- 1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)
- 2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
- 3-Deburr and blow out all chips from inside the tube

SL 7-10-11
ID

| | | |
|------|-----|-------------------|
| 11.0 | QC6 | DIMENSIONAL CHECK |
|------|-----|-------------------|



Comment: DIMENSIONAL CHECK

SL 07/10/11

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
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| | | |
|------|-----------|--------------|
| 12.0 | CR3212404 | Cherry Rivet |
|------|-----------|--------------|



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M104625

DP 7-10-15

(64)

| | | |
|------|--------|------------------|
| 13.0 | D26543 | 206 I-Beam (Web) |
|------|--------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

33060

SL 7-10-15

| | | |
|------|----------------|-------------------------|
| 14.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|------|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 7-10-15 Time: 8:40

Finish Date: 7-10-16 Time: 3:00

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

105586

Sikaflex expire date: 8-7-1

DP 7-10-15

SL 7-10-15

| | | |
|------|-----|------------------------------|
| 15.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/16

| | | |
|------|-------|------------------|
| 16.0 | D2649 | Crossbolt Spacer |
|------|-------|------------------|



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649

Crossbolt spacer

B34612

BE 07/10/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 33925A

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| | | |
|------|--------|--------|
| 17.0 | D32863 | Spacer |
|------|--------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B-32781 BE 7-10-17

| | | |
|------|----------------|-------------------------|
| 18.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|------|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M103138 BE 7-10-17

2-Grind welds flush as per Dwg D2650.

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod *NONE BE 7-10-17*

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

7-10-17

| | | |
|------|------------|--------------|
| 19.0 | CCR264SS33 | Cherry Rivet |
|------|------------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M103525 ② 7-10-17

| | | |
|------|----------|-------|
| 20.0 | M7885343 | Rivet |
|------|----------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3

Rivets

M102515 ② 7-10-17

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number: 33925A

Part Number: D206642241

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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| | | |
|------|----------|-----------|
| 21.0 | D2680041 | Nut Plate |
|------|----------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

73061 ① H 7-10-17

| | | |
|------|-----------------|----------------------------|
| 22.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

7-10-17

| | | |
|------|-----|---------------------------|
| 23.0 | QC9 | VISUAL WELDING INSPECTION |
|------|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

PD 07-10-18 ①

| | | |
|------|-----|------------------------------|
| 24.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/18 ①

| | | |
|------|-----------------|----------------------------|
| 25.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L

IX 07/10/24

| | | |
|------|----------------|----------------|
| 26.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

M 105063 BK 07-10-24

| | | |
|------|-----|---|
| 27.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|------|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/10/25 ①

| | | |
|------|--------|---------|
| 28.0 | D26483 | Wearpad |
|------|--------|---------|



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

BR 07-10-25

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

4 D2648-3

Wearpad

B34591

BR

29.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B31589

BR

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B33089

BR

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B29452

BR

32.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B34012

BR

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

or (see QSI 017)

M105729

BR

BR

07-10-25

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | |
|------|------------|--------|
| 34.0 | AN960JD10L | Washer |
|------|------------|--------|



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
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| | | | |
|----|------------|--------|----------|
| 44 | AN960JD10L | Washer | M 104885 |
|----|------------|--------|----------|

BR

| | | |
|------|------------|-------|
| 35.0 | MS27039108 | Screw |
|------|------------|-------|



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
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| | | | |
|----|--------------|-------|----------|
| 44 | MS27039-1-08 | Screw | M 104547 |
|----|--------------|-------|----------|

BR

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|------|--------|------|
| 36.0 | D26511 | Plug |
|------|--------|------|



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
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|----|---------|-------|---------|
| 18 | D2651-1 | Plugs | B 33185 |
|----|---------|-------|---------|

BR

| | | |
|------|--------|--------|
| 37.0 | D26513 | O-Ring |
|------|--------|--------|



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|----|---------|---------|---------|
| 18 | D2651-3 | O-Rings | B 33087 |
|----|---------|---------|---------|

BR

| | | |
|------|------------|-------|
| 38.0 | MS27039406 | Screw |
|------|------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|--------------|-------|---------|
| 1 | MS27039-4-06 | Screw | M 15194 |
|---|--------------|-------|---------|

BR

BR 07-10-25

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Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer *M 105426*

BR

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date:

M 105585
08-07

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

BR 07-10-25

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap *B 33289*

BR

42.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw *M 104547*

BR

BR 07-10-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:51:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33925A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M104885

HL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M105585
08-07

BL 07-10-25

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M106030

M 07-10-25

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-10-26

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BL 07-10-26

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D20664241 IF APPLICABLE

Location:

PPP Rev:

PPP 33925

AS LU

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-11-01

Job Completion



LU 07-11-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

103392SA
DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>1/1</i> | DRAWN BY <i>P</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>PH</i> | APPROVED <i>H</i> | DRAWING NO. D2650 | REV. E SHEET 1 OF 5 |
| DATE 06.03.30 | | TITLE 206/407 SKIDTUBE ASSEMBLIES | SCALE NTS |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | AS MANUFACTURED CHANGES | |
| C | 97.10.29 | CHANGE HOLE PATTERN AND FRONT END | |
| D | 04.05.17 | REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3 | |
| E | 06.03.30 | RMV C'BORE, CHG DRILL, ADD CHAMFER | |

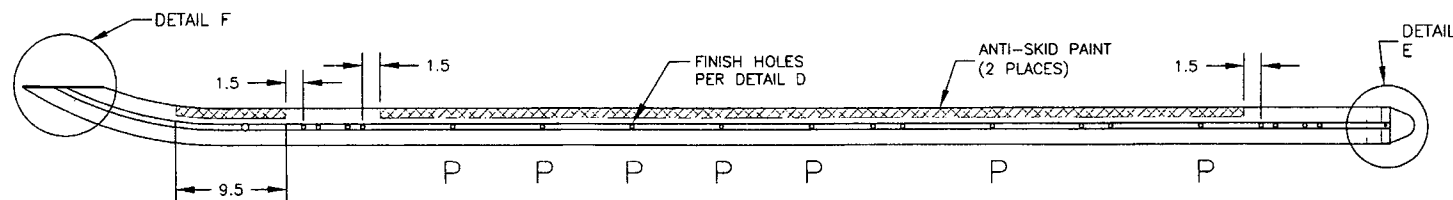
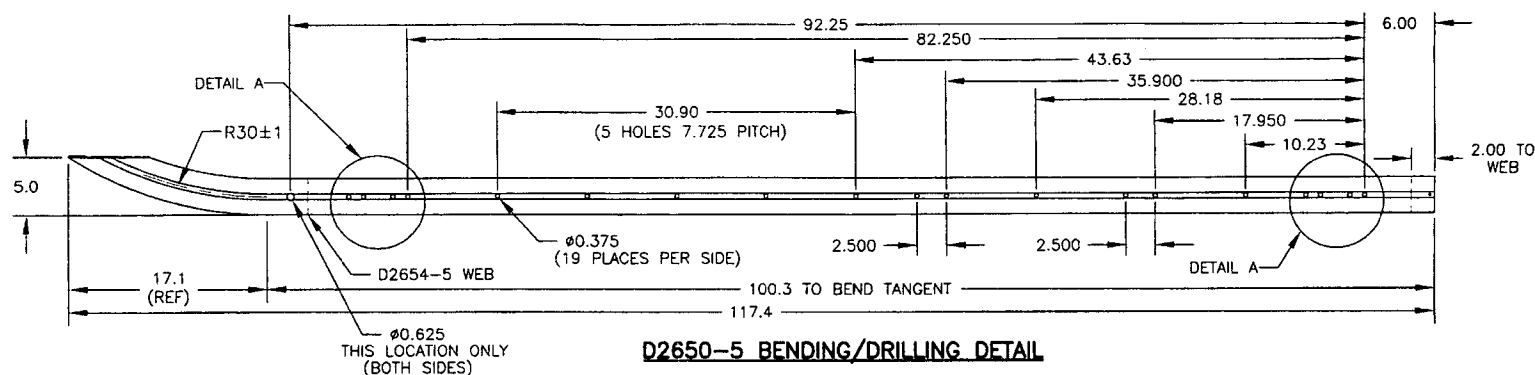
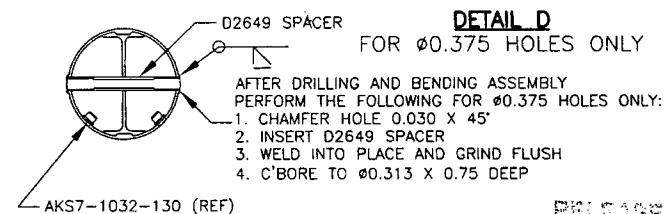
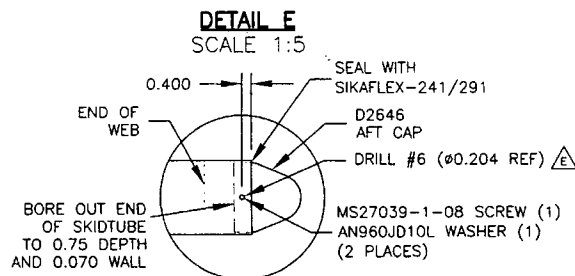
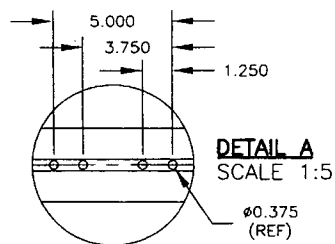
| Qty -1 | Qty -3 | Qty -5 | Qty -7 | Part Number | Description |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 16 | 17 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH:
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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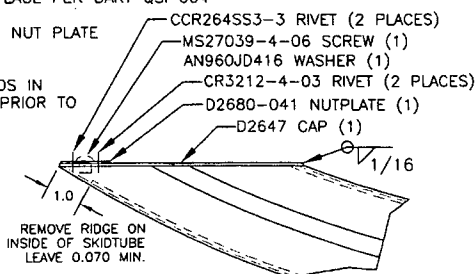
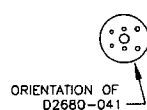
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DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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| | | | | |
|---------|----------|----------|----------|--|
| DESIGN | GP | DRAWN BY | GP | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | PH | APPROVED | PH | DRAWING NO. D2650 |
| DATE | 06.03.30 | TITLE | SKIDTUBE | REV. E SHEET 4 OF 5 SCALE 1:10 |

NO. 108

AWS D17.1.2001

QUALIFICATION TEST RECORD

Name Buckley, Philip
Joint Welding Procedure ES
Part Number and Job Number 8 D206 642 54 / B34580 9

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS TIG
Penetration Complete ☒ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC EX DC Backing YES ☐ NO ☒

| | Position | Vertical | Down | Up |
|--------------|----------|--------------------------|------|--------------------------|
| Sheet Groove | 1G | <input type="checkbox"/> | 2G | <input type="checkbox"/> |
| Tube Groove | 1G | <input type="checkbox"/> | 2G | <input type="checkbox"/> |
| Sheet Fillet | 1F | <input type="checkbox"/> | 2F | <input type="checkbox"/> |
| Tube Fillet | 1F | <input type="checkbox"/> | 2F | <input type="checkbox"/> |

Crossbolt Spacer Welded Yes Skidpipe

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-09-20

Qualifier RP